risate:

Thursday, 14/05/2009 3:41:15 PM

User: Julie Dawson **Process Sheet** : CU-DAR001 Dart Helicopters Services **Drawing Name** : MOUNTING LUG Customer Job Number : 47965 **Estimate Number** : 10256 **Part Number** : D22303 P.O. Number . D2230 REV F : 14/05/2009 S.O. No. : **Drawing Number** This issue : NC : N/A Prsht Rev. Project Number First Issue : // : MACHINED PARTS : F Type **Drawing Revision** : 47110 **Material Previous Run** 200 Um: : 21/05/2009 Each Qty: **Due Date** Written By Checked & Approved By Added inspection level 8, and removed P/O for Comment : Est D 00.05.18 powder coat **Additional Product** Job Number: **Description:** Seq. #: **Machine Or Operation:** Lug Extrusion Comment: Qty.: 14.3430 f(s) 0.0717 f(s)/Unit Total: Lug Extrusion D2423 Batch: <u>8437</u>22 LUG 2.0 Comment: Qty.: 1.0000 Each(s)/Unit 200.0000 Each(s) Total: LUG BAND SAW 3.0 BAND SAW ŕ Comment: Band Saw Cut D2423 extrusion to 0.82" 4.0 HAAS1 Comment: HAAS CNC VERTICAL MACHINING #1 Machine per folio D2230-3 Check for crack while loading into the machine. 5.0

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Dart Aerospace Ltd

W/O:		WORK	WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	GE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No: <u>D2230-3</u>	PAR #: _ NA	Fault Category:	Machined Partice: (es No	DQA:	Date: 05/04/1
Resolution:		Disposition:		11	Date: 09/06/1

NCR:4	1965	We	WORK ORDER NON-CONFORMANCE (NCR)							
DATE STE		Description of NC	Corrective Action Section B			Verification	Approval	Approval		
DAIL	STEP	01	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
09/05/a5	0,0	first apparation, blank was crooked	risian	scrap and replace aty 1 B 45722	~~~ 09/05/55	04/06/11	Postur	105 vb-08		
०३७१/२२	4.0	2 port lift when machining I charafer to deep. I part extra material not muchine good a part not Tight enough in 115 Reapp error	posiur	scrap and replace Oty 2 B 43722	m5- 09/05/25	20011		59.46.08		
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Thursday, 14/05/2009 3:41:15 PM Date: User: Julie Dawson **Process Sheet Drawing Name: MOUNTING LUG** Customer: CU-DAR001 Dart Helicopters Services Job Number: 47965 Part Number: D22303 Job Number: Description: Seq. #: **Machine Or Operation:** SECOND CHECK 6.0 QC8 Comment: SECOND CHECK SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1 7.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 1- deburr rough edges if necessary 8.0 HAND FINISHING Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 9.0 POWDER COATING POWDER COATING **Comment: POWDER COATING** Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3 10:30 Am START TIME: 3200F **OVEN TEMPERATURE:** 200 11:00 Am FINISH TIME: 10.0 QC3 Comment: INSPECT POWDER COATINSPECT POWDER COAT PACKAGING RESOURCE #1 11.0 **PACKAGING** Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 476 12.0 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Page 2

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W/O:			WO	RK ORDER CHANG	GES					· .
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Part No):	PAR #:	Fault Categ	jory:	NC	R: Yes	No DQ	A:	Date:	
	Resolution:		Disposition: QA: N/C Closed: Date:					Date: _	 ,	
NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NC	R)			
DATE	STEP	Description of NC			ection B		Verification		Approval	Approval
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DART AEROSPACE LTD	Work Order: 47965	2
Description: Mounting Lug	Part Number: D2230	-3
Inspection Dwg: D2230 Rev: F	Page 1	of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.450	+/-0.010	4.451	7			
0.413	+/-0.010	409	√			
0.306	+/-0.010	310	1			
3.700	+/-0.010	3.696	/			
0.750	+/-0.010	.751	>	,		
Ø0.257	+0.005/-0.000	. 258	>			
0.375	+/-0.010	.376	>			
R1.200	+/-0.010	R1,200	>			
0.100 x 45°	+/-0.010	.100×45°	\			
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Measured by:	Audited by:	Prototype Approval:	N/A
Date: 07/05/24	Date: 06/06/08	Date:	

Rev	Date	Change	Revised by	Approved
Α	03.11.11	New Issue	KJ/RF	- 14

Dart Aerospace Ltd

W/O:		WORK ORDER C	HANGES	IANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector			
Dart No										

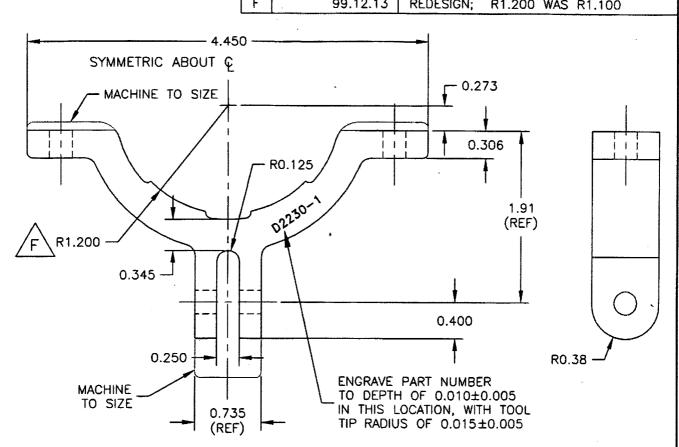
Part No:		PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed:	Date:

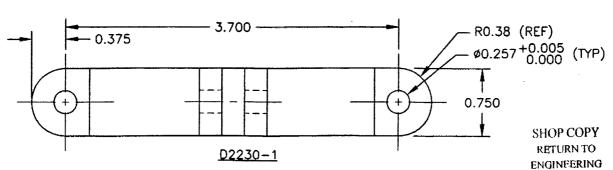
NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
DATE		Description of NC		Corrective Action Se	Verification	Approval Chief Eng	Approval QC Inspector				
DATE	STEP	Section A	Initial Action Description Chief Eng Chief Eng		Sign & Date			Section C			
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	DESIG	N	DRAWN BY	DART AFROCRAGE LTD
		ID	(I)	DART AEROSPACE LTD
i			0,	HAWKESBURY, ONTARIO, CANADA
	CHEC	(ED _M	APPROVED	DRAWING NO. REV. F
		*	1	D2230 SHEET 1 OF 2
	DATE			TITLE SCALE
	99.1	2.13		MOUNTING LUG 1:1
	С		94.03.30	RE-DESIGN
	D		95.01.04	RE-DESIGN
	Ε		95.01.04	RE-DESIGN
	F		99.12.13	REDESIGN: R1 200 WAS R1 100

RELEASE





MAKE FROM EXTRUSION D2423 BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 WORK ORDER

SUBJECT TO AMENDMENT WITHOUT NOTICE

UNCONTROLLED COPY

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Dart Aerospace L

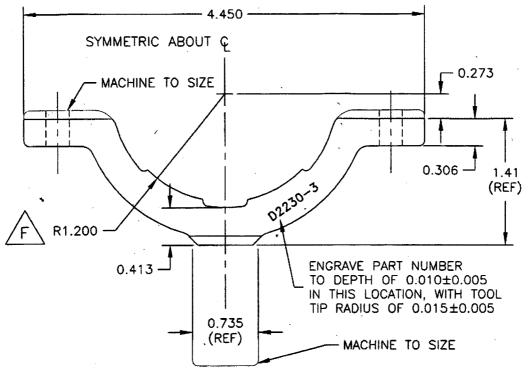
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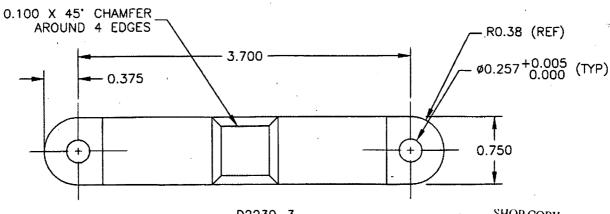




DESIGN	DRAWN BY		AEROSPACE L'	TD
CHECKED	APPROYED	DRAWING NO.		REV. F
#	-01	D2230	Si	IEET 2 OF 2
DATE		TITLE		SCALE
99.12.13		MOUNTING LU	G	1:1

RELEASED 199.02 21 DS





<u>D2230-3</u>

SHOP COPY RETURN TO

MAKE FROM EXTRUSION D2423 BREAK ALL EDGES 0.000-0.015 ENGINEERING UNCONTROLLED COPY

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

SUBJECT TO AMENDMENT WITHOUT NOTICE

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED NO

PO TER ORDER

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		Description of NC	Corrective Action Section B			Verification			Approval Approv	A	
DATE	STEP	Section A	Initial Action Description Chief Eng Chief Eng			Sign & Date		Section C		Approval QC Inspector	
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